

1-10. (Canceled)

a shank having a tapered outer perimeter surface;

a plurality of elastic engagement pieces abutting an outer perimeter surface of said tapered outer perimeter surface of said tool holder and being elastically deformable in a radial direction during a fitting; and

a plurality of ring shaped grooves formed at said inner surface section of said attachment hole of said main shaft at a predetermined interval along an axial center of said main shaft, said plurality of ring shaped grooves and said plurality of elastic engagement pieces being arranged in an alternating manner along said axial center;

said formation of said plurality of ring shaped grooves allowing said plurality of elastic engagement pieces to be integrally formed with said main shaft;

said plurality of elastic engagement pieces disposed at an inner surface section of said tapered attachment hole of said main shaft; and

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an elastic flange extending radially from said tool holder abuts an outer end surface of said main shaft and elastically deforms parallel with said axial center when said tool holder is mounted on said main shaft.

18. (Currently Amended) [[A]] The tool holder attachment structure, according to claim 16, further comprising:

an elastic flange extending radially from said tool holder abuts an outer end surface of said main shaft and elastically deforms parallel with said axial center when said tool holder is mounted on said main shaft.

19. (Currently Amended) [[A]] The tool holder attachment structure, according to claim 17, further comprising:

a ring shaped groove being formed at a radially inward position on said elastic flange;  
said elastic flange being formed with a ring shape; and

a ring shaped sloped groove being formed at a radially outward position on said elastic flange.

20. (Currently Amended) [[A]] The tool holder attachment structure, according to claim 11, wherein[[:]] said plurality of elastic engagement pieces are a plurality of collar shaped members secured to said inner surface section of said tapered attachment hole of said main shaft.





said plurality of elastic engagement pieces, each having a first length, extends from each respective ring-shaped groove to respective said inner perimeter section of said tapered attachment hole;

an end of each said elastic engagement piece arrayed in a plane parallel to said tapered outer perimeter surface of said shank, whereby each said elastic engagement piece contacts said tapered outer perimeter surface simultaneously during said insertion to provide easy alignment and tight attachment; and

said first length of each respective said elastic engagement piece being dependant upon a position on said tapered attachment hole relative to said tapered outer perimeter surface of said shank.